

ABSTRACT OF THE DISCLOSURE

A toner including toner particles of a styrene acrylate binder and at least one colorant, wherein the styrene acrylate binder has a weight average molecular weight of about 20 to about 30 kpse and a molecular peak of about 23 to about 28 kpse, the toner particles have a weight average molecular weight of about 28 to about 130 kpse, a number average molecular weight of about 9 to about 13.4 and a MWD of about 2.2 to about 10, and the toner particles have a cohesion of about 55 to about 98% at a mean circularity of about 0.94 to about 0.98. Also included is a set of toners for forming a color image, comprising a cyan toner, a magenta toner, a yellow toner and a black toner, wherein each of the cyan toner, the magenta toner, the yellow toner and the black toner have toner particles of about 70 to about 95% by weight, solids basis, of a styrene acrylate binder, about 5 to about 15% by weight, solids basis, of a wax dispersion, and at least one colorant.